

Date: Friday, 28/11/2008 3:10:34 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2891-1
Job Number : 43868	
Estimate Number : 13232	
P.O. Number :	Part Number : DSK076
This Issue : 28/11/2008 S.O. No. :	Drawing Number : DSK076 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 43384	Material :
Written By :	Due Date : 05/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.12.28</u>	
Comment : est rev A. 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6104003

Round Billet, 17-4



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Billet

Batch:

R43919

DP 05/12/18
SA 08/12/17

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE

Turn blank for as per Folio FA046

E
DOWSAN

DP 05/12/18
SA 05/12/17

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DP 05/12/18
SA 05/12/17

(10)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/12/18

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: CNC

DP 05/12/18

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/19

Job Completion



MF 08-12-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43868
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279						
B	3.702	3.722						
C	2.564	2.584		2.574	2.565	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.465	2.474	2.474	2.474
G	2.029	2.049		2.041	2.041	2.041	2.041	2.040
H	2.964	2.984		2.974	2.965	2.974	2.974	2.974
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110						
L								
M								
N								
O								
P								

Measured by: SA / [Signature]	Date: 08/12/17
Audited by: JL	Date: 08/12/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	43868
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

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F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
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J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110						
L								
M								
N								
O								
P								

Measured by:		Date:	08/12/17
Audited by:	J.L.	Date:	08/12/18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

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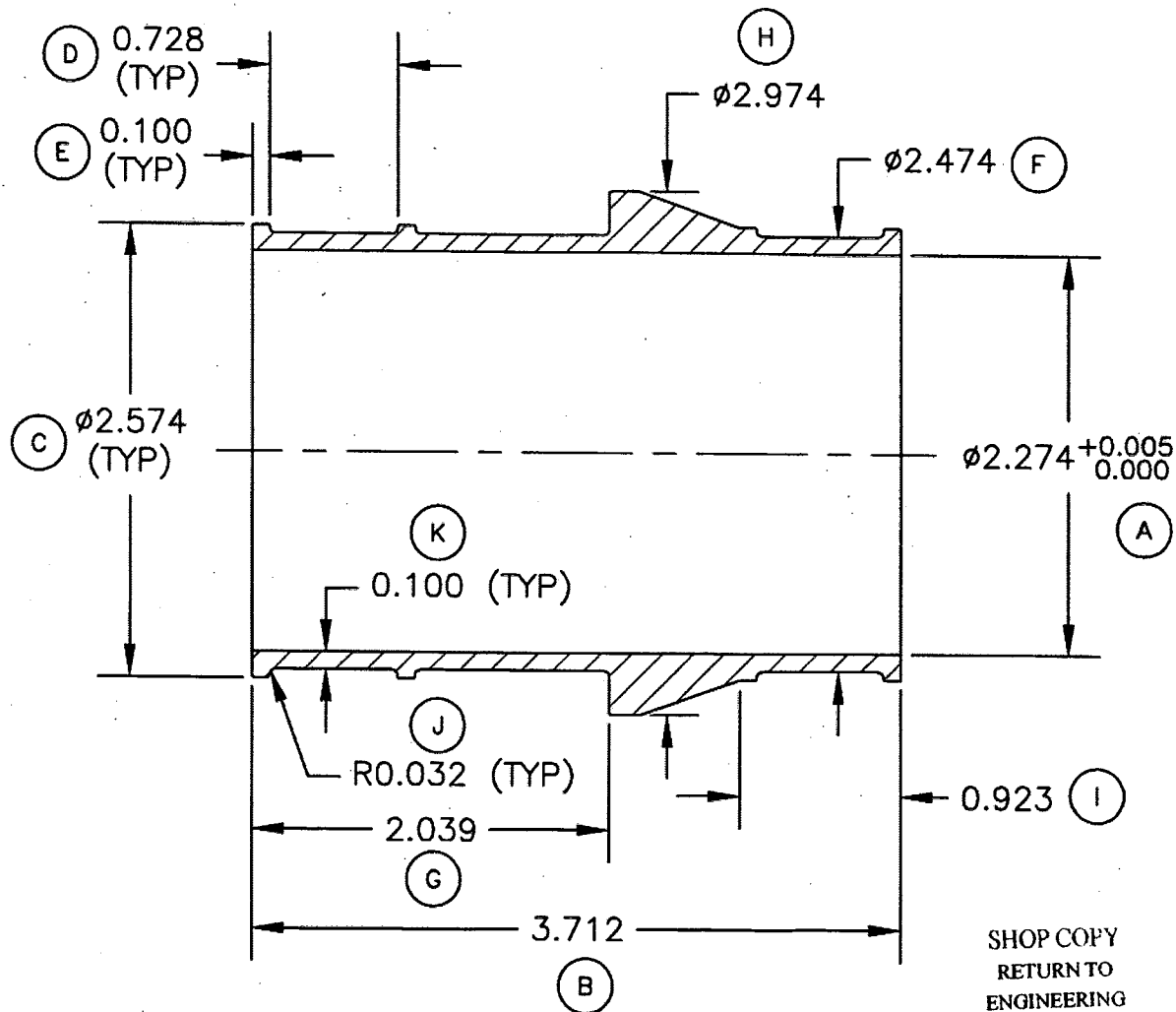
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 CH



D2891-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 43888

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